



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872533-2
Job Sheet 197093



Part No: RB6872533-2

Job Qty: 2 pcs

Part Name: Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/28/19

Job Tracking No:

Due Date: 8/10/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DWG RB6872533 Rev A IPP Rev. A 19.06.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	2 pcs	8/10/19	8/10/19	0.00	0.00	Purchasing - 1	JUL 30 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	8/10/19	8/10/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	JUL 30 2019
120	QC 6	2 pcs	8/10/19	8/10/19	0.00	0.00	QC 6 - 9	
							QC 6 - 68	
							QC 6 - 61	
							QC 6 - 40	AUG 01 2019
130	Packaging 3-1 - Stock - B4B	2 pcs	8/10/19	8/10/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
140	QC 21 - SA	2 pcs	8/10/19	8/10/19	0.00	0.00	QC 21 - SA - 21	
							QC 21 - SA - 70	
							QC 21 - SA - 53	

Part Op 100 - Issue P/O to P-MACHINAGE, P/O H6043955 - Manufacture RB6872533-2 as per DWG. -Certificate of
Descriptions: Conformity is required *Arrow Tech.*
110 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6872533-2P	Wrench	2 (1 ea)	100-Purchasing	5201610

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB6872533-2P	2	0	0

Part Specifications

Specifications could not be found.

Plex 7/9/19 8:31 AM dart.lussier.patrick



Quotation

PHGE Machine Works LLC dba
Arrow Tech Machine Works
29751 E. Enid Rd. Unit C
Eugene, Oregon 97402

Date
7/9/2019

Quote #
327

Phc (541) 780-6938
FA (458) 215-4938
Em atechmachineworks@gmail.com

Customer Details
Dart Aerospace

Payment Terms
Withing 30 days due net
Contact
Patrick Lussier

Sales Rep
Gabriel Escobar

Qty	Item	Description	Unit Price	Amount
2	RB6872533-2 REV-A	WRENCH	\$ 657.50	\$ 1,315.00

Thank You

Subtotal	\$	1,315.00
Freight		
Payment and Credit Applied		
Total	\$	<u>1,315.00</u>

P.J. Machinage (9052 9470 Qc Inc).
 1381, Rte Cité-Des-Jeunes,
 St-Lazare, Qc
 J7T 2B8
Tel. : 450 455-0705

Bid

08/07/2019

16398

Sales Rep. : Peter Jones
Reference : Part #RB6872533-2
Expiration Date : 07/08/2019

Customer : 628

Dart Aerospace Ltd.
 Patrick Lussier
 1270 Aberdeen St
 Hawkesbury, Ontario
 K6A 1K7

Ship To :

Same

Item No.	Description	Qty	Price	Total	Tx
001	Part # RB6872533-2 Wrench only, no handle *** Including Heat Treat *** *** Without Black Oxide *** Material supplied by P.J. Machinage Price valid : Conditionaly if full order is given and there is only one setup and one shipment, if not, surcharges may apply. Machining price valid 30 days. Material price valid 1 day only, due to USA Freight charge not included. Delivery is to be discussed the day we receive the purchase order.	2	640.00	1 280.00	AB

P.J. MACHINAGE
 LISEZ ATTENTIVEMENT ET CORRIGEZ
 LES ERREURS ÉVENTUELLES. NOUS NE
 POURRONS PAS ÊTRE TENUS
 RESPONSABLES POUR LES ERREURS,
 APRES QUE VOTRE APPROBATION AIT
 ÉTÉ DONNÉE.

SIGNATURE _____ DATE _____

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or performed for its customer until full and complete payment of the underlying invoice, even in circumstances where the part to be machined or materials were provided by the customer. In cases where the part of materials belonged to the customer before it is remitted to P.J. Machinage for the prupose of performing work thereon, its delivery to P.J. Machinage shall entail a transfer of the underlying rights of ownership of the customer over said part or materials

Note: All the COD Clients must pay 50% up front and the balance must be paid upon reception.

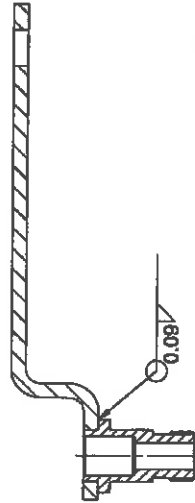
A) Regist : 870637832
 B) Regist : 1021079932

Subtotal 1 280.00
TPS : 64.00
TVQ : 127.68

Total : 1 471.68

	Initiales	Date
Préparé	MS	08/07/19
Révisé		

ITEM #	QTY	PART #	PART TITLE
-1	1	RB6872533-1	HANDLE
-2	1	RB6872533-2	WRENCH

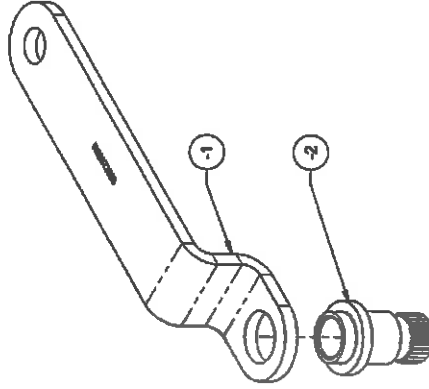
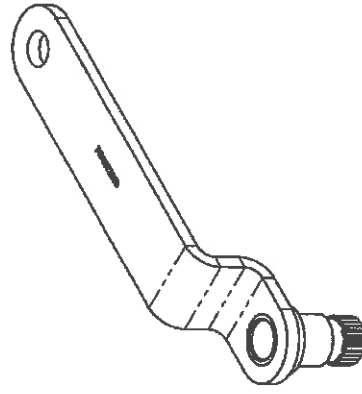


SECTION A-A

RB6872533 WRENCH AND HOLDER INSTREM COMPRESSOR TIE BOLT

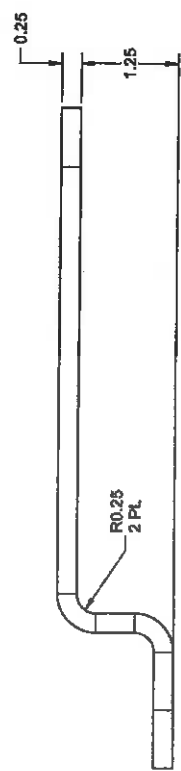
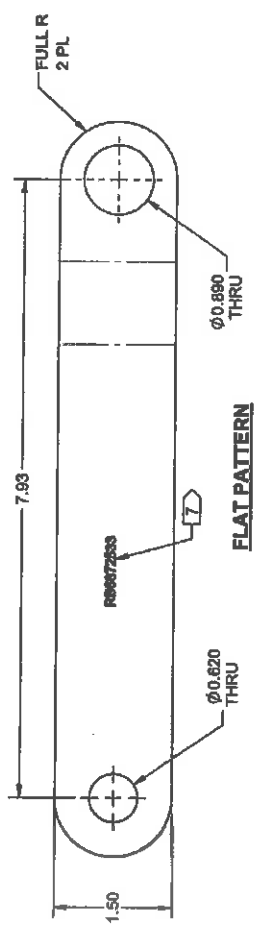
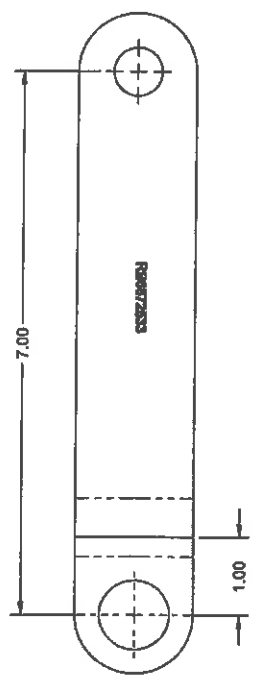
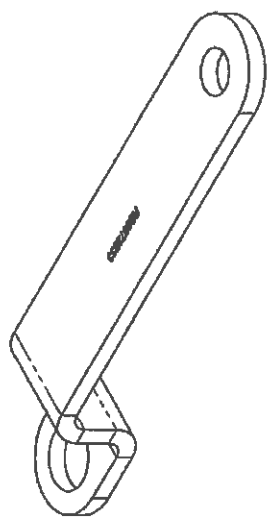
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: 46-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81308 TYPE III OR MIL-C-23411A OR MIL-PRF-81308 AND WIPE OFF EXCESS
- 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.1"$
 XXX = $\pm 0.01"$ / $\pm 0.5"$
 XXXX = $\pm 0.005"$ / $\pm 0.1"$
 XXXXX = $\pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$ UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



A	NEW ISSUE	DESCRIPTION	EDN #	BY	VM
REV.					
DRAWN	VM				
CHECKED	VM				
MFG. APPR.	PK				
APPROVED					
DATE	2019-06-26				
TOOL PART #		DART AEROSPACE LTD			
RB6872533		HAWKESBURY, ONTARIO, CANADA			
TITLE		WRENCH AND HOLDER INSTREM COMPRESSOR TIE BOLT			
REV. A		SHEET 1 OF 3			
SCALE		N/A			
CONFIRMED BY DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA			
DATE		2019-06-26			

1 2 3 4 5 6 7 8



RB6872533-1 HANDLE

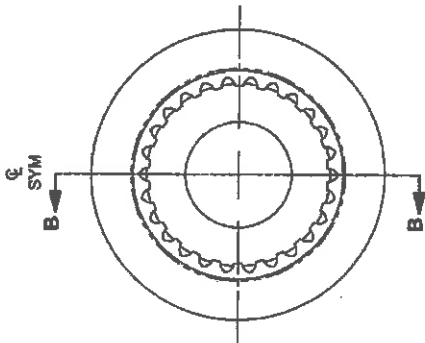
NOTES:

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK TYN, "RB6872533", AS SHOWN

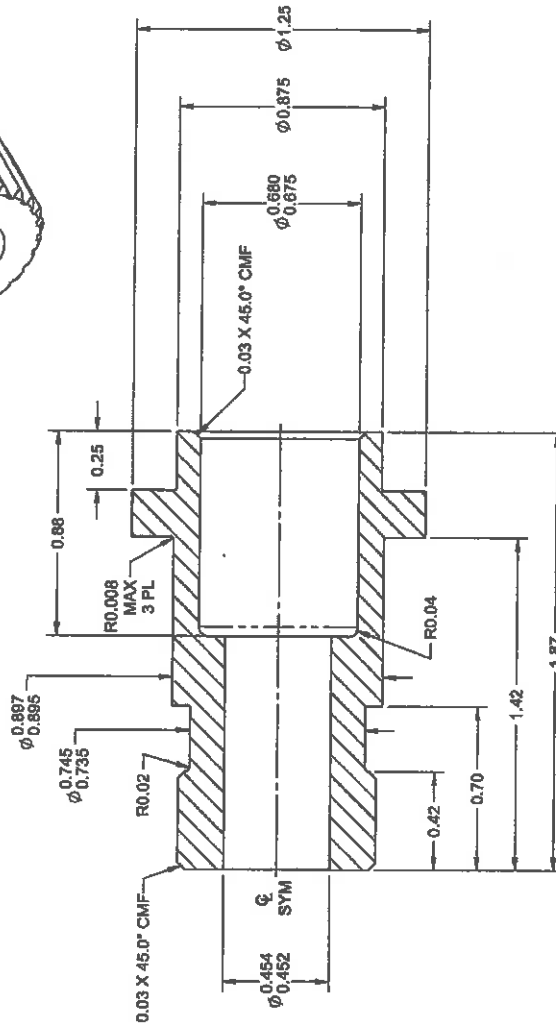
DESIGN	VM	VM	DART AEROSPACE LTD
DRAWN	VM	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	NPT	NPT	TOOL PART #
MFG. APPR.	FW	FW	RB6872533
APPROVED	WFP	WFP	TITLE
DATE	2019-06-26	2019-06-26	WRENCH AND HOLDER INSTRUM COMPRESSOR TE BOL NTS
REV. A			SHEET 2 OF 3
SCALE			1:1
COPYRIGHT © 2019 BY DART AEROSPACE LTD			ALL RIGHTS RESERVED
NO REUSE OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD			

SPLINE INFO:

32/64 PITCH 26 TEETH
 PRESSURE ANGLE : 30.0°
 ARC TOOTH THICKNESS : 0.0441" ± 0.002 "
 ROOT DIA : 0.762"
 PITCH DIA : 0.8125"
 OUTSIDE DIA : 0.844 ± 0.005 "
 BASE CIRCLE DIA : 0.7036
 DIMENSION OVER TWO 0.0540" DIA PINS : 0.8805 ± 0.0033



RB6872533-2 WRENCH



SECTION B-B

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES:
 - XX = ± 0.1 " / $\pm 1^\circ$
 - XXX = ± 0.01 " / $\pm 0.5^\circ$
 - XXXX = ± 0.005 " / $\pm 0.1^\circ$
 - XXXXX = ± 0.0005 " / $\pm 0.05^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 7) REMOVE ALL SHARP EDGES AND BURRS
- 8) IDENTIFICATION: N/A

DESIGN DRAWN	VM	DATE 2019-06-26
CHECKED	VM	
MFG. APPR.	KPT	
APPROVED	PK	
TOOL PART # RB6872533		
TITLE WRENCH AND HOLDER INSTATION COMPRESSOR TE BOL NTS		
REV. A SHEET 3 OF 3		
SCALE N/A		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		

THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC WITHOUT RESTRICTIONS
 UNLESS INDICATED OTHERWISE



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043955



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043955

PO Date: 7/9/19

Due Date: 7/30/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	197093	RB6872533-12P			Wrench REV A	Firmed	-	7/30/19	2 Ea	0 Ea	2 Ea	\$657.50/Ea	\$1,315.00
Line Item Note please do heat treat 48-52 as per drawing but do not do Black Oxide Finish													
												Grand Total:	\$1,315.00

Order Notes

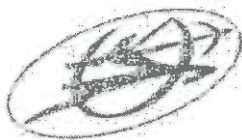
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 7/9/19 1:19 PM dart.lussier.patrick

Master AB # 8128 4801 7350



PHGE Machineworks dba
Arrowtech Machineworks
29751 E Enid Rd.
Eugene, Oregon 97402
Phone: (541) 780-6937
Fax: (458) 215-4938

COMMERCIAL INVOICE

No: 642

Date: 7/27/2019 ✓
PO Ref: HB043955 ✓
Ship via: FEDEX
Customer No: 17

SHIP TO ADDRESS:

Dart Aerospace
1270 Aberdeen St.
Hawksbury, ON
CANADA, K6A1K7
Phone: (613) 632-5200

This shipment does not contain hazardous materials.

Qty	Price	Item	Part No.	Total
2 ✓	657.50	WRENCH	RB6872533-2 REV B ✓	\$ 1,315.00

(HS CODE FOR ALL ITEMS IS
8207195030)

TOTAL: \$ 1,315.00

Packaged by:
Checked by:

Thank You

RECEIVED

JUL 30 2019

DART AEROSPACE LTD.



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043955 ✓ Dated: 7/27/2019

Our Order / Job No: HB043955-1AWT Order Qty: 2 ✓

Part Name: WRENCH

Part Number RB6872533-2 ✓

Lot Size: N/A Ship Date: 7/27/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6872533-2 Rev: B

Material Size and Type: O1 STEEL

Material Specifications: STEEL: ASTM A681

Heat Treatment: 48.0 – 48.0 HRC

Plating/Finish: N/A

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 7/25/19.

Signed: Herbert M. Ralston

DAS
81
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com